

Work Order ID 73794

Thursday, September 15, 2011 10:39:08 AM

Page 1

Item ID: D2654-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Web

Start Date: 9/15/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2654

Rev E1

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2654 (73.85")
2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654
3-Using the uni-bit, open holes to finish size as per Dwg D2654
4-Deburr holes and ends

110

QCS- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish

Memo

0.00

Hand Finishing

12 11/10/18

10 5 BE 11/10/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73794

Thursday, September 15, 2011 10:39:09 AM



Page 2

Item ID: D2654-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Web

Start Date: 9/15/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

DP

11-10-18

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 46

0.00

DP

11-10-18

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

11/10/19

QC

Memo

0.00

Quality Control

11-10-18

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Picklist Print

Page 1

Thursday, September 15, 2011 10:39:05 AM

Work Order ID: 73794



Parent Item: D2654-1

Parent Item Name: Web

Start Date: 9/15/2011

Required Date: 10/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM
IPP Rev:E 08-06-10 revE1 as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-108-80

Manufactured No

100

Each

131.0000

1

10



SAD 11-10-17

Extrusion 'I Beam' thin

Location

Loc Qty

Loc Code

HALL

48

273 867

47814

48

10

LG

83

47814

83

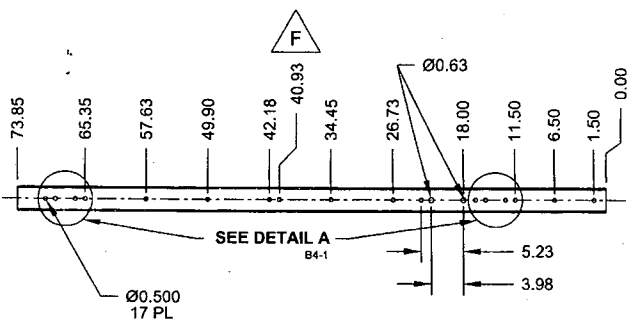
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

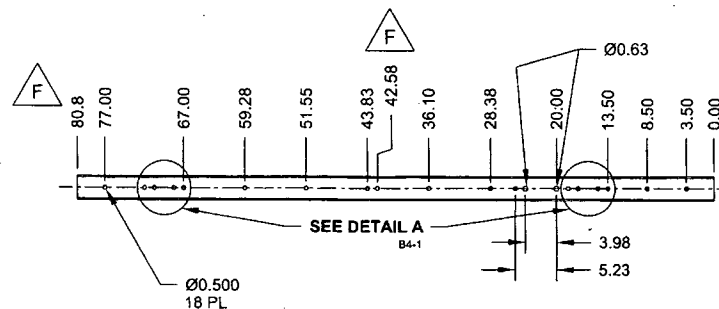
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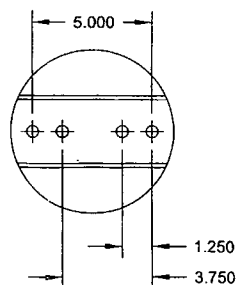
NOTE: Date & initial all entries



D2654-1 WEB



D2654-3 WEB



DETAIL A

C2-1
C3-1
C5-1
C8-1
D3-2
D6-2
B3-2
B6-2

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

W673794

RELEASED
2011-09-12
W

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>9</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>E</i>	D2654	SHEET 1 OF 2
APPROVED	<i>10</i>	TITLE	SCALE
DE APPR.	<i>11</i>	WEB	NTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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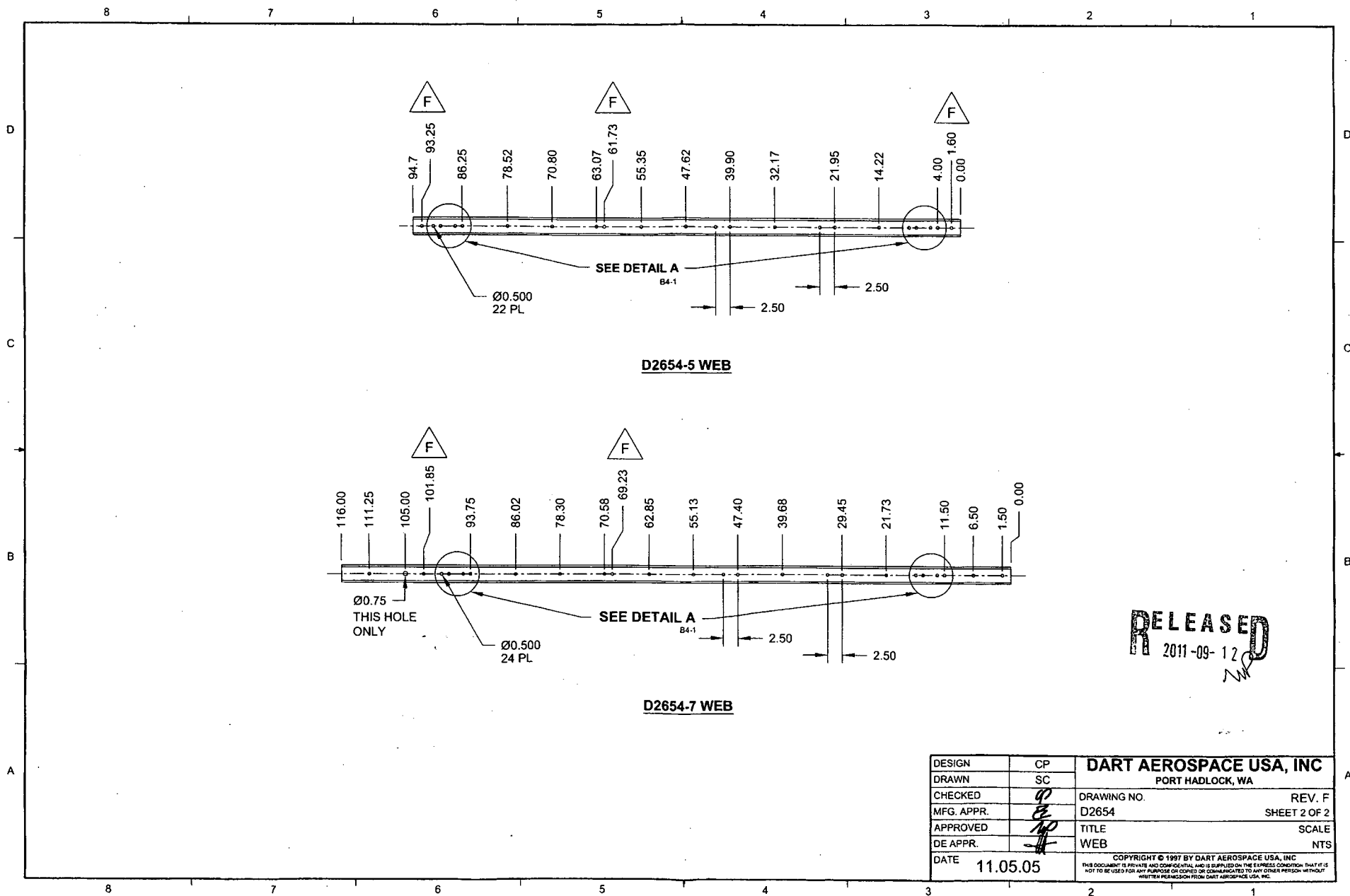
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